

5/23

DART AEROSPACE LTD	Work Order:	23140
Description: Wearshoe	Part Number:	D2656-13
Drawing: D2656 Rev. C	Qty:	50
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	RF	05.04.29	50
2	PG	Issue P/O: 2004903 Email or ship DXF file to vendor Laser Cut per Dwg D2656 flat pattern D2656-13 Material release note required	CL	05-05-03	50
3	RG	Receive and Inspect for transit damage Ensure the material note is attached	CL	05/05/16	50
4	QC6	Inspect dimensions per template D2656-13T1 DRAWING	ML	05/05/25	50
5	GB	Deburr if necessary	N/A, ML	05/05/25	50
6	GB	Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326	FF	05.08.15	50
7	GB	Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13	FF	05.08.17	50
8	QC5	Inspect work to Step 7	J	05.08.18	50
9	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	FC	05.08.21	50
10	QC3	Inspect Powder Coat	ML	05.08.23	50
11	FP	Identify and Stock	FC	05.08.24	50
12	AC	Cost / part: 14.02	FC	05.08.28	50
13	DC	Close W/O 13.58 Inspect Level 21	(13)	05.08.25	50

Rev	Date	Change	Revised By	Approved
B	99.03.16	Re-format	DM	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	
D	01.04.10	In house process	EC	
E	01.06.26	Added step 2 to 4, added inspection level 21	EC	
F	02.10.25	Re-format	KJ RF	

RELEASED
02/10/30 RF

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

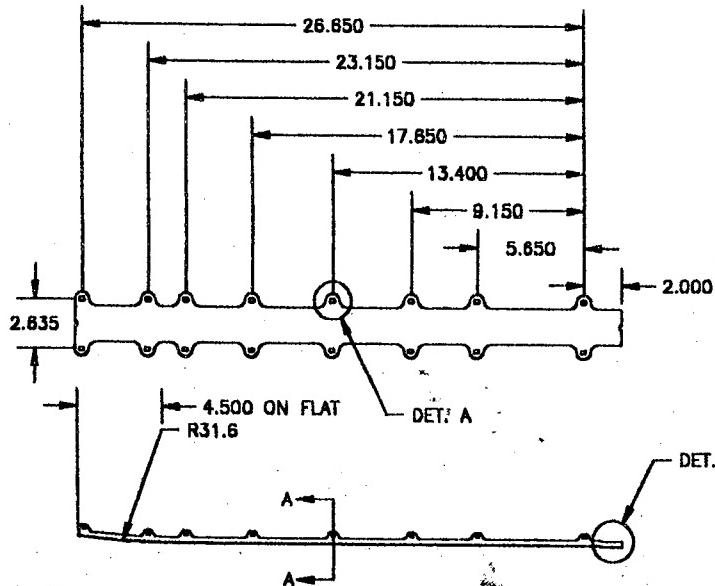
NCR: Yes No DQA: *[Signature]*Date: *05/08/25*

NOTE: Date & initial all entries

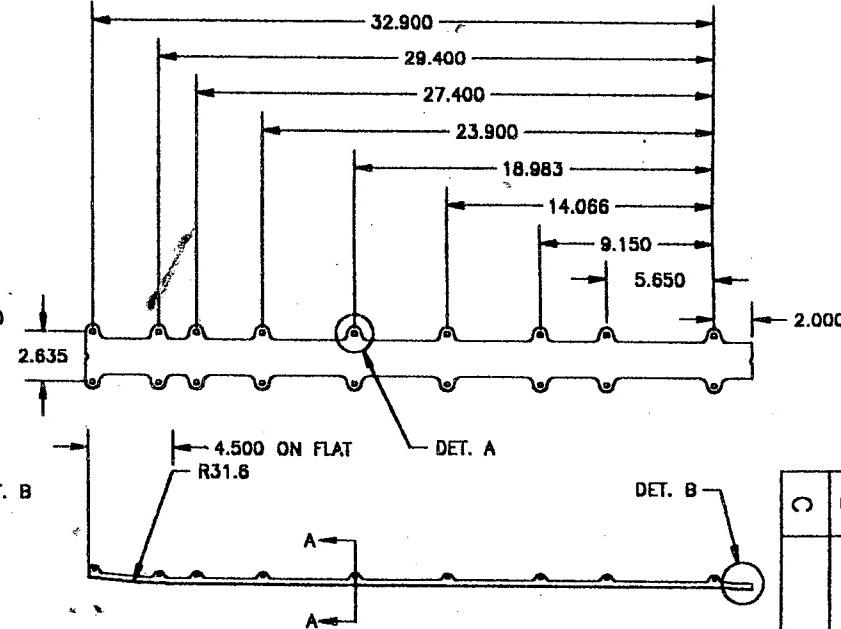
QA: N/C Closed: _____

Date: _____

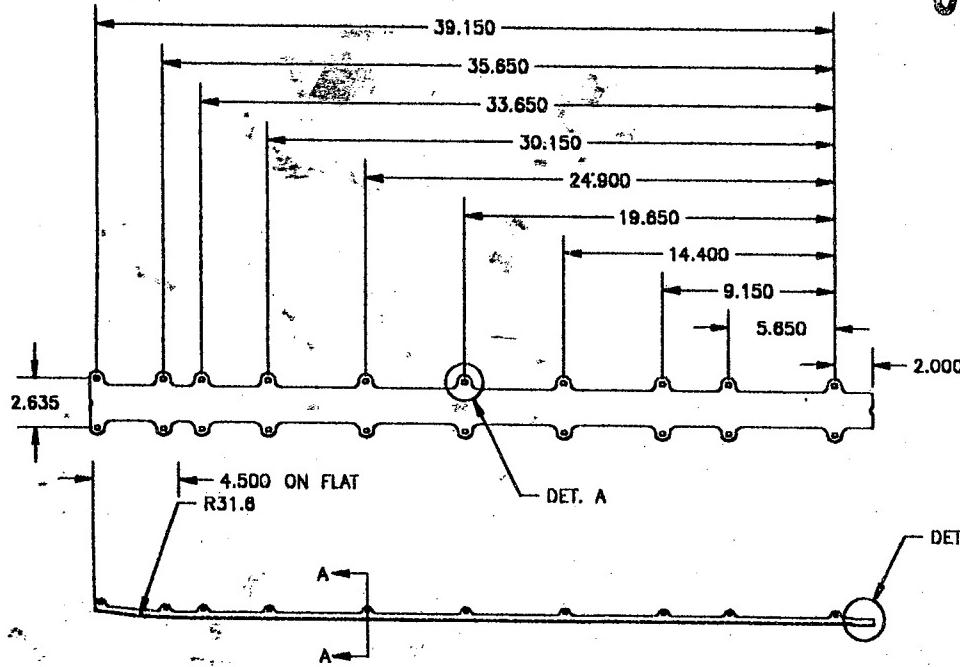
D2656-11



D2656-13



D2656-15



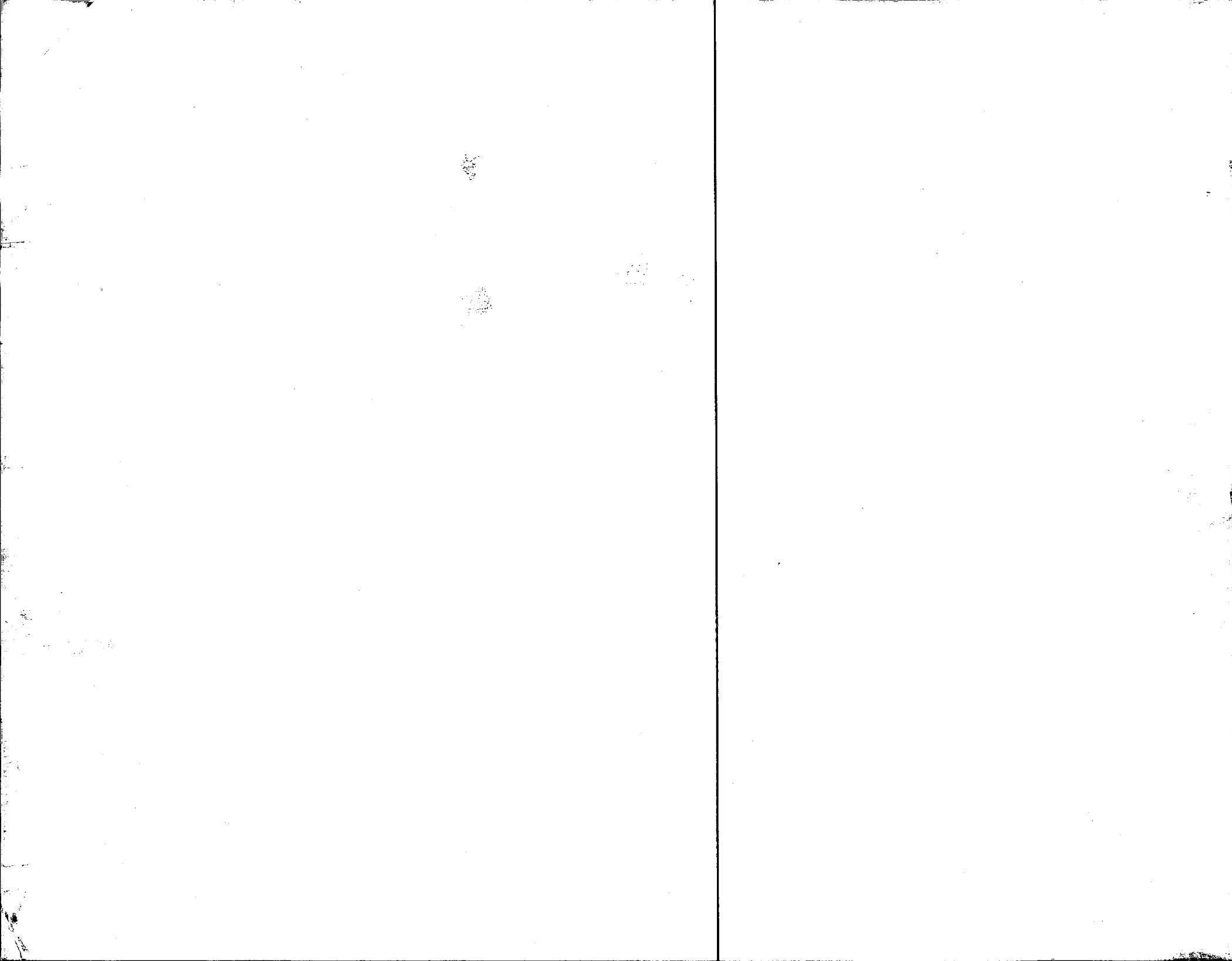
CONTROLLED COPY

MATERIAL: AISI 1000 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
47/06/27 DS

DART

DESIGN BY	DRAWN BY	DART AEROSPACE USA, INC
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, USA
DATE	REVISION	REV. C
<i>MM</i>	<i>BW</i>	D2656
97:06:26		SHEET 1 OF 4
A	97:03:25	SCALE 1:10
B	97:06:02	
C	97:06:26	
		WEARSHOE
		TITLE
		D2656



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 29, 2005
11:31 am

Work Order No	:	0023140	Department Code:	
Project Name	:	D2656-13	Burden Flags	: NNNNNNN
Project For	:	WK523	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2656-13	Invoice Number	:
Description	:	Wearplate	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	50	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	04-29-05	Est. Mark Up	: 0.000%
Est Finish Date	:	06-05-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>		<hr/>	<hr/>	<hr/>	<hr/>
Burden	: 0.00	0.00	0.00		
<hr/>		<hr/>	<hr/>	<hr/>	<hr/>
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00



New Zealand Steel Limited
Clymbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 3758 989 Auckland
(09) 2568 009 Waikato
Fax: (09) 3758 959 Telex 24938

TEST CERTIFICATE

Ref: 3561/12931

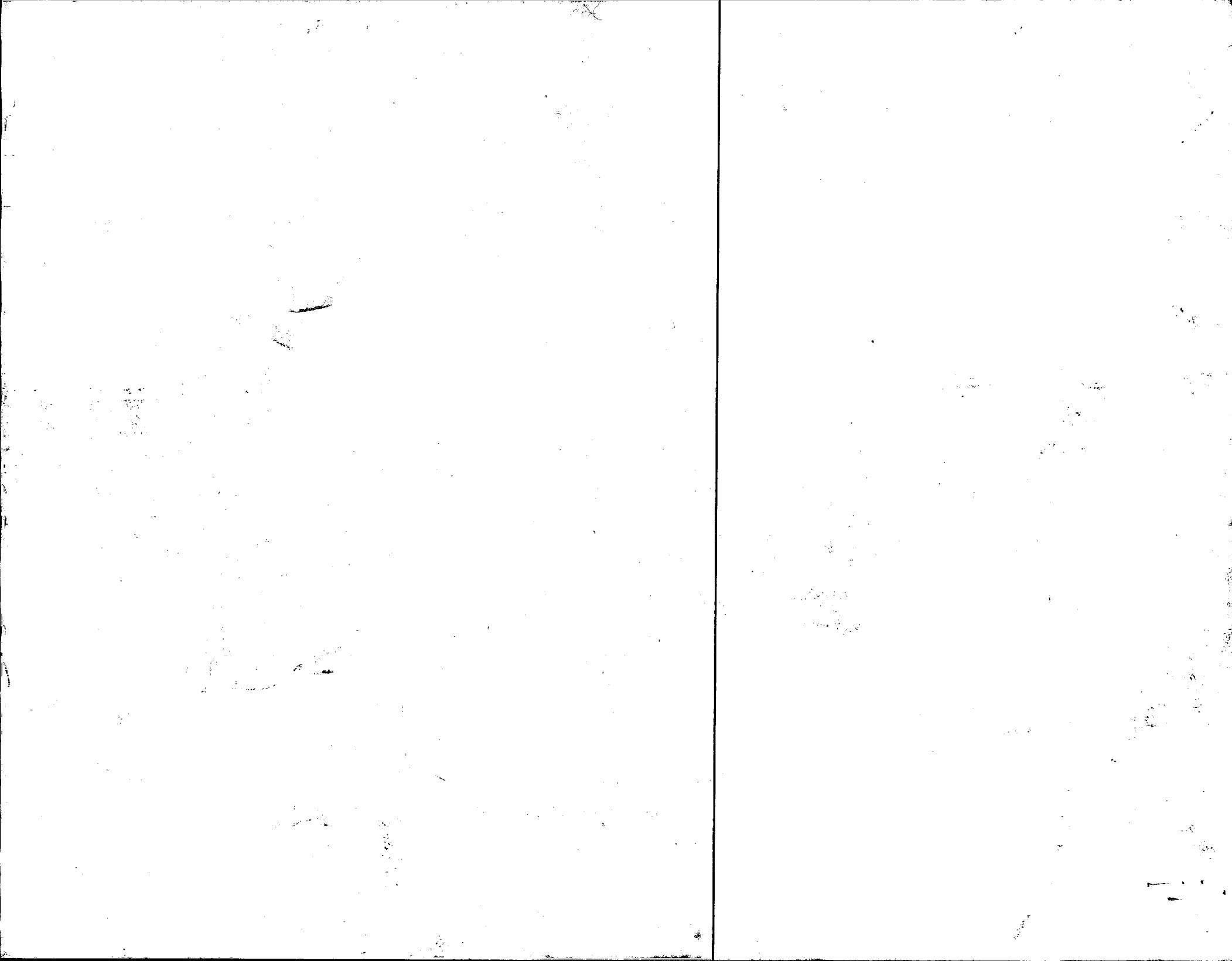
CUSTOMER	Wilkinson	P 3043011001	SPECIFICATION	ASTM A1008 CS Type A	CERTIFICATE No	TC072790																		
CUSTOMER O/N	90-21N-141		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																		
MILL O/N	375624		DIMENSIONS	0.033" x 48" x Coil	DATE	29 August 2003																		
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT						MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)																
		C x100	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B x1000	N2 CE() x10000	CE() x100	BEND 180° x100	YIELD	T.S. GL =	%ELONG. HRB	HARDNESS ()	r	LENGTH (feet)
R9-413484-00	625796	5	TR	20	8	9	12	18	20	1	5	1	1	1					Good			44		2467
R9-413485-00	625796	5	TR	20	8	9	12	18	20	1	5	1	1	1					Good			44		2589
R9-414003-00	625794	5	1	20	8	11	12	18	21	3	6	1	1	1					Good			49		2644
R9-414004-00	625794	5	1	20	8	10	12	18	21	3	6	1	1	1					Good			49		2690

20 GA MS.

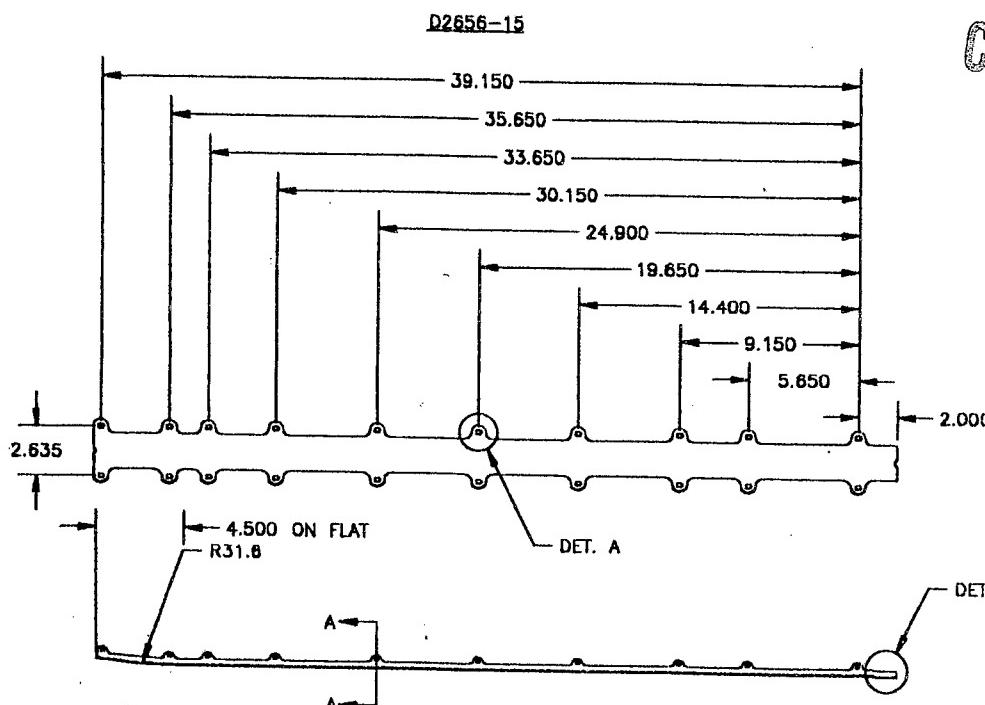
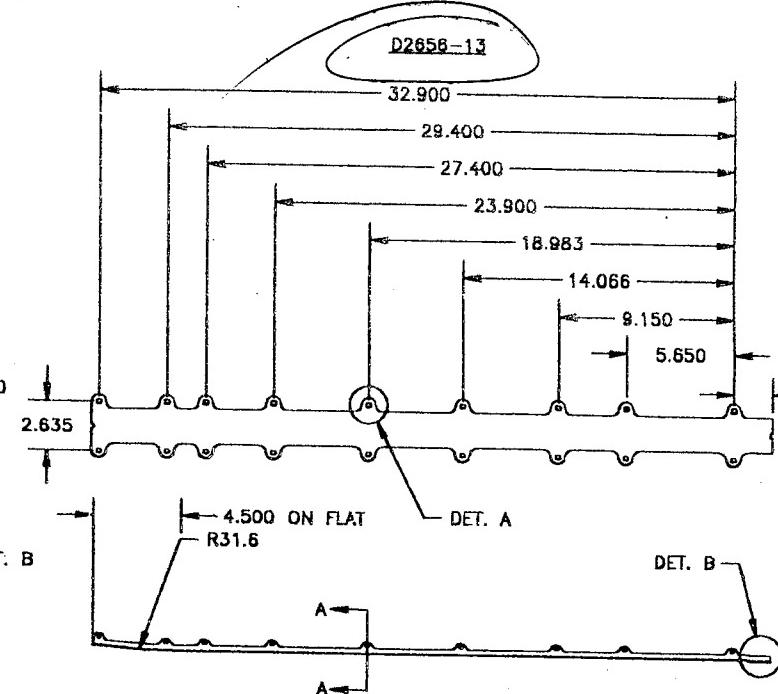
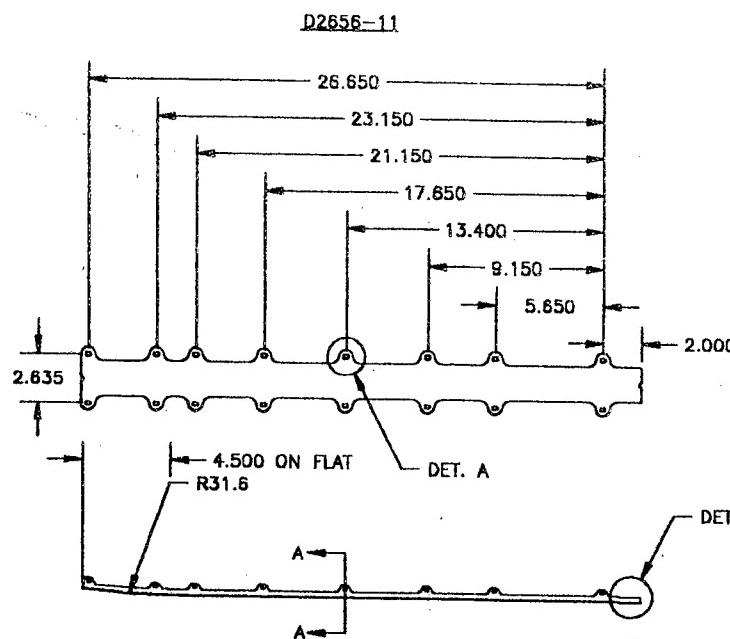
YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm (C)=80mm (D)=5.65, So (E)=2° (F)=8°	PLASTIC STRAIN RATIO (r) (A)=r0 (B)=r0 (C)=r/(r0+180+2r45)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+V/8+(C+V+Mo)5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Batch Misra*
QC METALLURGIST



DART



CONTROLLED COPY

MATERIAL: AISI 1000 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED
(7/06/27) DS

DESIGN BY	DRAWN BY	DART AEROSPACE USA, INC
CHECKED	APPROVED	FARNSWORTH INTERNATIONAL AIRPORT, USA
<i>DW</i>	<i>KF</i>	
<i>DW</i>	<i>BW</i>	DRAWING NO.
DATE		D2656
97:06:26		TITLE
A	97:03:25	WEARSHOE
B	97:06:02	CHANGED TABS
C	97:06:26	R31.6 WAS R19.5
		SCALE
		1:10
		SHEET 1 OF 4
		REV. C

